

Work Order ID 132718

Thursday, May 07, 2015 2:56:43 PM

132718

Page 1

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Bracket
 Start Date: 5/7/2015 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 5/7/2015 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: CL Date: MAR 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B								

100 FLOW WATER JET 0.00 18 Ø Jm15-5-19
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary
5052 .040

110 QC2- Inspect parts off machine FAI/FAIB 0.00 18 Ø Jm15-5-19
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00 18 Ø Jm15-5-19
120
 QC Memo 0.00
 Quality Control

DAG
38
9-89

MAY 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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[illegible]

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 131545.</i> Memo START TIME: <i>2:25</i> <i>3:00</i> FINISH TIME: <i>2:35</i>	0.00 0.00				<i>18</i>	<i>10-5-26</i>		
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(18)</i>			<i>DAS</i> <i>38</i> <i>9-89</i> MAY 27 2015
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST481</i> Memo	0.00 0.00				<i>18</i>	<i>27</i>		MAY 27 2015

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Work Order ID 132718

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132718

Page 4

Item ID: D2583

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Bracket

Start Date: 5/7/2015 Start Qty: 16.00

16

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MJS MAY 28 2015

MJS MAY 28 2015

DQA: _____ Date: _____



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Picklist Print

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Page 1
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132718

Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased			No	100	sf	29.0984	0.1169	1.968842			

M5052H32S 040

5052-H32 .040 Sheet

**

②

Jm 15-5-19

Location

Loc Qty

Loc Code

MAT

25

m131653

25

MAT023

4.0984

m129530

4.0984

131653.

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OTHER : ☐					

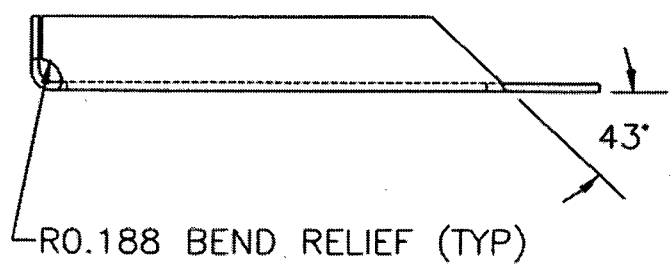
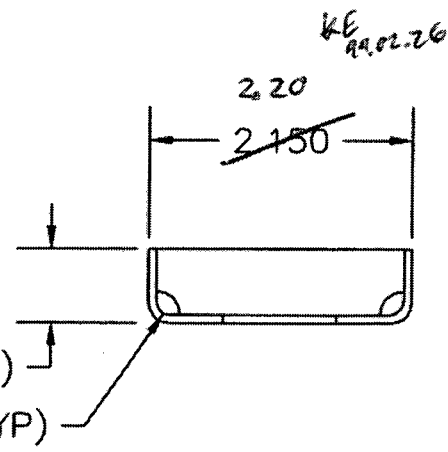
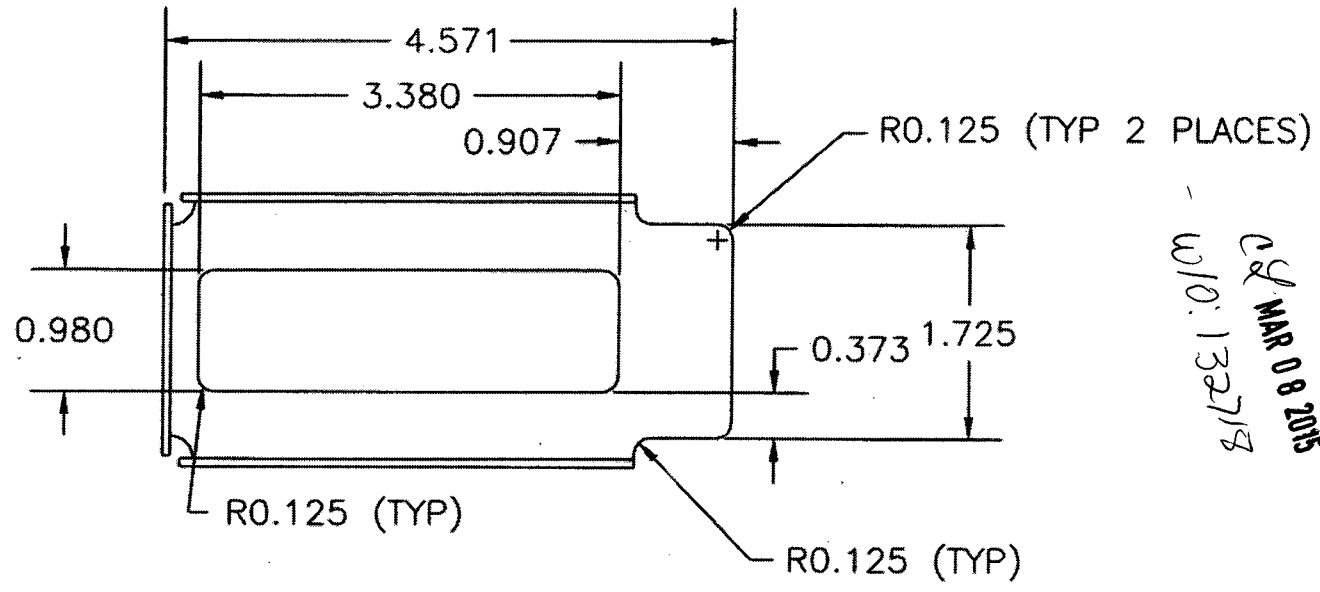
DART



RELEASED
KE 99.02.25

CD MAR 08 2015
W/O: 132718

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B
A	96.07.10	NEW ISSUE		SHEET 1 OF 1
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		SCALE 2:3



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

